

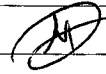
Work Order ID 125923

Friday, October 24, 2014 2:17:00 PM

125923

Page 1

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 10/24/14 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 11/28/14 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan:  Date: 14-10-24 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3500	C

100	HAAS CNC VERTICAL MACHINING #1	0.00				40	0		 DAS 37 9-89 14-11-15
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100

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Program Batch No. 125923 Double check by  1-Machine Step No 1
 per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step
 No 2 per Folio FA641and inspect per attached Dimension Sheets3-Machine
 Step No 3 per Folio FA641 and inspect p

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00


 DAS
 37
 9-89 14-11-15

120

QC8- Inspect parts - second check

0.00

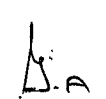
120

QC

Quality Control

Memo

0.00

 14/11/24


 DAS
 08
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125923

Friday, October 24, 2014 2:17:00 PM

125923

Page 2

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 10/24/14 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 11/28/14 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130	HandFinish	0.00							
Hand Finishing	Memo								
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140	Powdercoat	0.00							
Powder Coating	Memo								
	START TIME: <u>8:40</u> OVEN TEMPERATURE: <u>410</u>								
	FINISH TIME: <u>9:10</u>								
150	QC3- Inspect Part Finish	0.00							
150	QC	0.00							
Quality Control	Memo								

DEC 17 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125923***125923***

Page 3

Friday, October 24, 2014 2:17:00 PM

Item ID: D3500-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle

Start Date: 10/24/14

Start Qty: 40.00

40

Cust Item ID:

Required Date: 11/28/14

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: **\$406**

0.00

160

Packaging

Memo

0.00

Packaging

40**JAN 06 2015****DAS
66
8-89**

170

QC21 - Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

15/1/6**ME
15-01-06**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, October 24, 2014 2:18:00 PM

Page 2

Work Order ID: 125923

125923

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 10/24/14

Required Date: 11/28/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6102-013		Manufactured	No			100	Each	108.0000	1	40		DAS 37 9-89	
D6102-013									**			14.11.15	

Saddle Billet

Location	Loc Qty	Loc Code
MAT040	32	
104299	22	
105554	10	10
MAT042	20	
121061	20	
MAT044	20	
120357	20	
MAT046	36	
109518	10	
110225	6	
110994	8	
111533	12	8
125927		22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

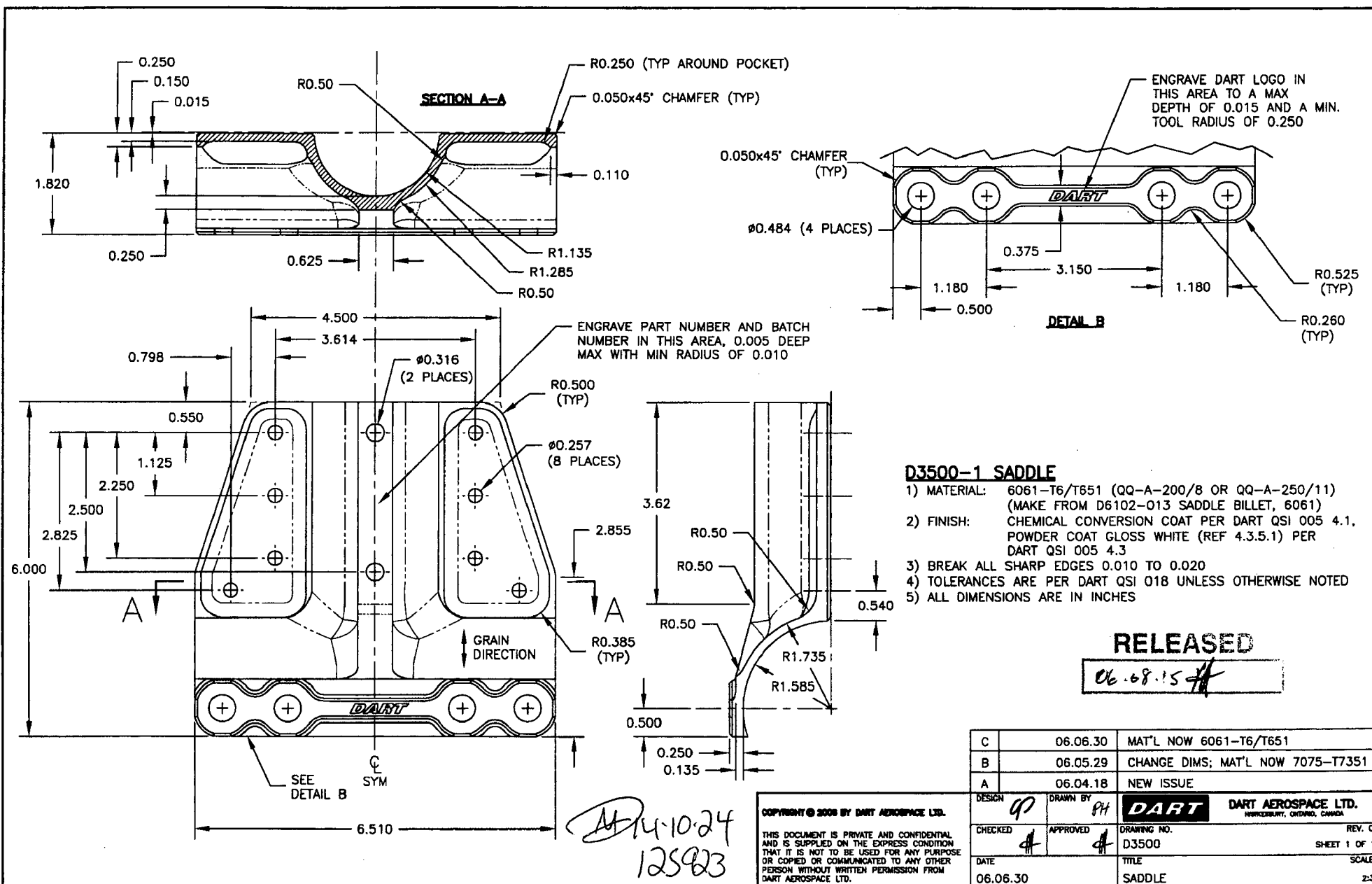
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.378	.378	.378	.378		
F	0.490	0.510		.499	.501	.500	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.588	1.590	1.587		
J	0.240	0.260		.245	.246	.245	.246		
K	0.490	0.510		.498	.499	.501	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520	6.512	6.512	6.510	6.509	6.510		
P	5.990	6.010	6.002	6.002	6.001	6.000	6.001		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.548	.549	.548	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.131	1.132	1.133	1.131		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.256	.254	.255	.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.253	.254	.253	.254		
AG	0.140	0.160		.149	.150	.151	.150		
AH	0.140	0.160		.149	.151	.150	.150		
AI	0.140	0.160		.151	.149	.151	.149		
Accept/Reject				✓	✓	✓	✓		

Measured by:	37 9.89
Date:	14/11/15

Audited by:	D. A.	DAS
Date:	14/11/29	08
		9-89

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.378	.378	.378	.378		
F	0.490	0.510		.499	.500	.501	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.588	1.587	1.588		
J	0.240	0.260		.245	.246	.246	.247		
K	0.490	0.510		.499	.500	.501	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.511	6.510	6.510	6.511		
P	5.990	6.010		6.001	6.000	6.002	6.001		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.549	.550	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.132	1.133	1.132	1.1325		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.252	.253	.252	.253		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.249	.250	.249		
AG	0.140	0.160		.156	.150	.149	.150		
AH	0.140	0.160		.150	.150	.149	.1505		
AI	0.140	0.160		.150	.151	.150	.151		
Accept/Reject				—	✓	—	—		

37

Measured by:	9-89
Date:	14-11-16

Audited by:	H.A.	DAS
Date:	14/11/29	08
		9-89

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				9	10	11	12		
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.378	.378	.378	.378		
F	0.490	0.510		.499	.498	.499	.497		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.589	1.588	1.587		
J	0.240	0.260		.246	.247	.247	.245		
K	0.490	0.510		.499	.500	.500	.498		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.011	6.010	6.009	6.511		
P	5.990	6.010		6.001	6.001	6.001	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.551	.552	.547		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.137	1.136	1.136	1.130		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.251	.251	.250	.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.251	.249	.251		
AG	0.140	0.160		.151	.150	.149	.150		
AH	0.140	0.160		.151	.150	.149	.154		
AI	0.140	0.160		.149	.151	.150	.155		
Accept/Reject				✓	✓	✓	✓		

Measured by: 37	Audited by: J.A.	DAS
Date: 14/11/16	Date: 14/11/29	08
		9-83

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				13	14	15	16		
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.370	.370	.370	.370		
F	0.490	0.510		.498	.499	.500	.498		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.584	1.588	1.584		
J	0.240	0.260		.245	.246	.245	.246		
K	0.490	0.510		.499	.500	.498	.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.511	6.510	6.511		
P	5.990	6.010		6.001	6.006	6.001	6.001		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.548	.549	.548	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.131	1.133	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.254	.254	.253	.253		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.251	.249	.250		
AG	0.140	0.160		.150	.151	.151	.150		
AH	0.140	0.160		.149	.154	.155	.149		
AI	0.140	0.160		.150	.150	.149	.150		
Accept/Reject				✓	✓	✓	✓		

Measured by: 37	Audited by: H.A.	DAS
Date: 14.11.16	Date: 14/11/29	08
		9-89

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				17	18	19	20		
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.378	.378	.378	.378		
F	0.490	0.510		.498	.499	.498	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.589	1.588	1.590		
J	0.240	0.260		.245	.245	.246	.247		
K	0.490	0.510		.499	.501	.500	.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.511	6.510	6.511	6.510		
P	5.990	6.010		6.001	6.001	6.000	6.001		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.548	.549	.548	.548		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.131	1.130	1.131	1.131		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.253	.254	.253	.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.251	.251	.251	.250		
AG	0.140	0.160		.151	.151	.150	.151		
AH	0.140	0.160		.151	.151	.150	.150		
AI	0.140	0.160		.150	.150	.147	.149		
Accept/Reject				✓	✓	✓	✓		

37		DAS	
Measured by:	9-89	Audited by:	H. a
Date:	14.11.16	Date:	14/11/29
			08
			9-89

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				18 21	19 22	20 23	21 24		
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.378	.378	.378	.378		
F	0.490	0.510		.498	.498	.498	.498		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		R1.590	R1.586	R1.588	R1.590		
J	0.240	0.260		.245	.246	.247	.248		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.511	6.510		
P	5.990	6.010		6.003	6.003	6.003	6.001		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.548	.546	.547	.548		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		R1.133	R1.132	R1.135	R1.136		
AB	R.490	R.510		.500	.500	.500	.520		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.254	.258	.256	.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.251	.250	.251	.251		
AG	0.140	0.160		.154	.149	.150	.150		
AH	0.140	0.160		.154	.160	.159	.159		
AI	0.140	0.160		.151	.160	.160	.160		
Accept/Reject									

Measured by: 37	Audited by: B.2	DAS
Date: 12/11/17	Date: 14/11/19	08
		9-82

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				25	26	27	28		
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.378	.378	.378	.378		
F	0.490	0.510		0.498	0.498	0.498	0.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		R1.588	R1.599	R1.587	R1.589		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.500	0.499	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.003	6.000	6.001	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.546	0.546	0.546	0.547		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		R1.137	R1.133	R1.132	R1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		0.251	0.252	0.253	0.252		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.250	0.251	0.251	0.251		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.154	0.155	0.156	0.158		
AI	0.140	0.160		0.157	0.157	0.157	0.157		
Accept/Reject									

Measured by: 37 9-89	Audited by: DAS 08
Date: 14.11.17	Date: 14/11/29 9-89

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				29	30	31	32		
A	0.483	0.490		0.484	0.484	0.484	0.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.378	0.378	0.378	0.378		
F	0.490	0.510		0.501	0.501	0.500	0.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		R1.587	R1.586	R1.586	R1.590		
J	0.240	0.260		0.248	0.247	0.247	0.250		
K	0.490	0.510		0.498	0.498	0.497	0.498		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.001	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	0.547	0.547	0.54		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		R1.133	R1.131	R1.134	R1.137		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.625	0.625	0.625	0.625		
AD	0.240	0.260		0.255	0.254	0.254	0.253		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.251	0.250	0.250	0.250		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.158	0.157	0.157	0.154		
AI	0.140	0.160		0.158	0.158	0.158	0.158		
Accept/Reject									

Measured by:	
Date:	14/11/23

Audited by:		DAS
Date:	14/11/23	08

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				33	34	35	36		
A	0.483	0.490		0.484	0.484	0.484	0.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.378	0.378	0.378	0.378		
F	0.490	0.510		0.499	0.499	0.500	0.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		R 1.584	R 1.585	R 1.587	R 1.585		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.500	0.498	0.498	0.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	0.547	0.546	0.547		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		R 1.135	R 1.133	R 1.133	R 1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.625	0.625	0.625	0.625		
AD	0.240	0.260		0.253	0.255	0.255	0.253		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.250	0.251	0.251	0.251		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.150	0.157	0.157	0.157		
AI	0.140	0.160		0.158	0.158	0.158	0.156		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	14/11/23

Audited by:	D.A.	DAS
Date:	14/11/23	08 9-09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125923
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				37	38	39	40		
A	0.483	0.490		0.484	0.484	0.484	0.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.378	0.378	0.378	0.378		
F	0.490	0.510		0.498	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.588	1.586	1.587		
J	0.240	0.260		0.248	.246	.246	.246		
K	0.490	0.510		0.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	.550	.550	.550		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.135	1.132	1.130	1.130		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.625	0.625	0.625	0.625		
AD	0.240	0.260		0.253	.252	.256	.257		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.254	.252	.253	.253		
AG	0.140	0.160		0.150	.151	.151	.151		
AH	0.140	0.160		0.155	.154	.158	.158		
AI	0.140	0.160		0.154	.151	.156	.158		
Accept/Reject									

Measured by:	CMF
Date:	14/11/23

Audited by:	AS	DAS
Date:	14/11/23	08
		9:00

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA